

Date: Thursday, 5/11/2006 11:52:08 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 27056	
Estimate Number : 10530	
P.O. Number : N/A	Part Number : D2571
This Issue : 5/11/2006 S.O. No. : N/A	Drawing Number : D2571 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 26972	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 5/30/2006
Checked & Approved By : J. G. 06.05.11	Qty: 12 Um: Each
Comment : Est: 10270.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
7075-T7351 8.25X7.75X2.5
Make from D6101-007 billet for D2571
Ensure that grain is along 7.75" length
Batch No: _____

B24070 x 12

En 06/05/15

12

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. 27056 Double check by: J.G.

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove sharp edges.

En 06/05/19
J.G.

06/05/16

12

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572

En 06/05/19
J.G.

06/05/16

12

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 06/05/19
J.G.

06/05/17

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/05/2006

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 5/11/2006 11:52:08 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 27056

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ML 06/05/23 (12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Q.M 06/05/24 (12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.M 06-05-25 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AL 06/05/25 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST478*

AL 06/05/25 (12)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/05/26 (12)

Job Completion



W 06-05-26

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order: 27056
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.749	1.748	1.748		
C	3.495	3.505		3.498	3.497	3.497	3.498		
D	1.745	1.755		1.749	1.749	1.750	1.748		
E	7.990	8.010		8.002	8.003	8.004	8.004		
F	0.490	0.510		0.501	0.498	0.499	0.490		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.502	0.501	0.503	0.499		
J	1.174	1.184		1.180	1.180	1.180	1.178		
K	0.558	0.578		0.568	0.569	0.567	0.567		
L	1.174	1.184		1.180	1.180	1.179	1.178		
M	1.490	1.500		1.502	1.501	1.502	1.494		
N	2.495	2.505		2.501	2.502	2.501	2.498		
O	3.869	3.879		3.874	3.873	3.872	3.872		
P	0.115	0.135		0.124	0.121	0.120	0.123		
Q	0.115	0.135		0.126	0.124	0.123	0.135		
R	0.240	0.260		0.241	0.242	0.243	0.253		
S	0.115	0.135		0.126	0.126	0.127	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.962	2.963	2.960		
V	0.230	0.250		0.244	0.247	0.248	0.239		
W	0.115	0.135		0.119	0.120	0.124	0.120		
X	0.308	0.313		0.312	0.310	0.311	0.316		
Y	0.760	0.765		0.761	0.761	0.760	0.765		
Z	0.352	0.372		0.364	0.365	0.365	0.368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.634	0.630	0.629	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.244	0.244	0.248		
AE	1.375	1.395		1.387	1.387	1.391	1.389		
AF	0.115	0.135		0.127	0.128	0.127	0.135		
AG	0.240	0.280		0.245	0.246	0.248	0.260		
AH	0.240	0.260		0.253	0.254	0.250	0.252		
AI	2.000	2.020		2.002	2.002	2.005	2.004		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: J.G. / Ep	Audited by: Jm
Date: 06/05/17	Date: 06/05/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27056
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.748	1.749	1.748	1.747		
C	3.495	3.505		3.499	3.496	3.498	3.496		
D	1.745	1.755		1.748	1.749	1.748	1.747		
E	7.990	8.010		8.003	8.002	8.002	8.002		
F	0.490	0.510		0.491	0.491	0.498	0.497		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.496	0.498	0.499	0.501		
J	1.174	1.184		1.175	1.176	1.178	1.175		
K	0.558	0.578		0.560	0.560	0.568	0.564		
L	1.174	1.184		1.175	1.176	1.178	1.175		
M	1.490	1.500		1.493	1.492	1.493	1.492		
N	2.495	2.505		2.497	2.499	2.498	2.496		
O	3.869	3.879		3.871	3.874	3.873	3.871		
P	0.115	0.135		0.127	0.128	0.123	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.252	0.249	0.252		
S	0.115	0.135		0.125	0.124	0.124	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.245	0.237	0.235	0.238		
W	0.115	0.135		0.120	0.120	0.118	0.117		
X	0.308	0.313		0.311	0.311	0.311	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.368	0.370	0.371	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.625	0.624	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.247	0.247	0.247		
AE	1.375	1.395		1.388	1.389	1.387	1.388		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.252	0.257	0.248	0.249		
AI	2.000	2.020		2.003	2.004	2.001	2.001		
AJ	0.023	0.043		0.033	0.033	0.030	0.030		
Accept/Reject									

Measured by:	S.G./Co
Date:	06/05/17

Audited by:	me
Date:	06/05/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27056
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

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				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.745	1.717	1.750	1.745		
C	3.495	3.505		3.497	3.497	3.496	3.498		
D	1.745	1.755		1.745	1.717	1.750	1.745		
E	7.990	8.010		8.004	8.003	8.004	8.003		
F	0.490	0.510		0.497	0.494	0.498	0.492		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.496	0.498	0.499	0.500		
J	1.174	1.184		1.177	1.175	1.177	1.177		
K	0.558	0.578		0.565	0.563	0.565	0.561		
L	1.174	1.184		1.177	1.175	1.177	1.177		
M	1.490	1.500		1.492	1.492	1.493	1.493		
N	2.495	2.505		2.496	2.496	2.498	2.494		
O	3.869	3.879		3.872	3.873	3.872	3.872		
P	0.115	0.135		0.125	0.117	0.127	0.129		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.244	0.252	0.254		
S	0.115	0.135		0.125	0.124	0.128	0.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.239	0.239	0.240	0.241		
W	0.115	0.135		0.118	0.120	0.118	0.117		
X	0.308	0.313		0.310	0.310	0.309	0.309		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.369	0.367	0.367	0.368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	0.628	0.626	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.246	0.248	0.244		
AE	1.375	1.395		1.388	1.385	1.387	1.389		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.252	0.248	0.251	0.249		
AI	2.000	2.020		2.003	2.001	2.002	2.004		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		

Accept/Reject

Measured by:	ED
Date:	06/05/19

Audited by:	JM
Date:	06/05/23




Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. 06102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

 $\triangle E$

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
		DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. D2571
DATE 05.07.13		TITLE OUTER FWD SADDLE
		REV. SHEET 1 OF 2
		SCALE 2"

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DART AEROSPACE LTD.

DETAIL C
SCALE 4:3

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WITHOUT NOTICE
WORK ORDER
NO. 27052

